

**Make it safe. Clean it up. Close it down.**

Plutonium risks eliminated

## Criticality no longer possible in 771/774

By Joel Zarrett

As B771 workers packaged the last of highly contaminated filters from FU2B filter plenum in early May, plutonium risks in the “most dangerous building in America” were eliminated.

Since 1994, when a DOE working group declared the building the most dangerous plutonium facility in the complex, workers have labored to clean up the facility. Thousands of liters of plutonium solutions were drained, 240 gloveboxes, 397 tanks and miles of process piping were also removed and packaged.

B771 earned the 1994 distinction because of the danger posed by 15,000 liters of plutonium solutions in process piping, tanks and 4-liter bottles stored in gloveboxes. The more than 50kg of hold up plutonium oxide remaining in B771 ducts, filter plenums and other process equipment, contributed to the working group’s findings. The group also cited the radioactive decay of plutonium in the presence of water, which causes water to break apart into its component atoms, as a significant hazard.

Hydrogen, a highly explosive gas, had been accumulating in process piping for years and indeed posed imminent danger to crews when they began tapping and draining pipes in 1998.

A Criticality Accident Alarm System (CAAS) is required in any facility that stores more than 450g of fissionable material with a greater than one-in-a-million probability of a criticality event in a year. DOE Orders also require comprehensive criticality safety programs that implement strict controls on how



*Steelworkers and project team members successfully transformed B771/774 to crit incredible.*

work in nuclear buildings is performed and how nuclear materials and waste are packaged and stored.

“The state of B771 was the most dangerous on site, maybe anywhere, from a criticality perspective, because nowhere else was such a substantial amount of plutonium present in liquid form. Scenarios involving liquid systems were the most credible of those we analyzed in criticality accident analyses,” said Howard Gilpin, B771 manager of ESH&Q. Several aqueous processes were used in B771 to recover plutonium from residues and convert it to plutonium metal.

A recent independent criticality evaluation determined that a criticality event in B771 is no longer credible. Demolition crews can now

remove conduit and other CAAS hardware, as part of structural decontamination. The criticality incredible designation is a significant milestone leading to demolition of the buildings.

According to Tom Dieter, B771/774 project manager, “Safely achieving the designation is a result of the tremendous efforts of the Steelworkers and other project team members who by eliminating remaining risks in the buildings have reduced hazards to the public and to the environment.”

Bob Richardela, Area 4 Project Manager announced that B559 was also determined to be criticality incredible on May 16, bringing the laboratory one step closer to deactivation. Look for a story about B559 in an upcoming issue of *Endvision*.

## Steelworkers chalk up another success



From left to right on the stairs: James Rau, Al Amador, Harvey Beaver, Chuck Staudinger, Steve Orendorff, Joe Candelaria, Marcia Tildon (client), Bret Clauson, Virgil Kyles. From left to right on top of tank: Grover Holmes, Howard Hall, Dan Carter (client), Chuck Cown, Mike Scanlon, Chris Campbell (client), Al Smith, Michael Barajas, and Rufus Barajas. Not pictured are Frank Arellano and Greg Harman.

By Bill Badger

Last June, 15 Q-cleared Rocky Flats employees worked in temperatures that fluctuated from below freezing to 100+ degrees with snow changing to sleet, then rain then sunshine all in one day. The wind howled as the Steelworkers worked to fabricate and erect two tanks. But the extreme weather conditions did not occur at Rocky Flats. Rather, the team of Steelworkers were working on a project north of Las Vegas, Nev.

– Please see **STEELWORKERS SUCCESS** on page 4

### What's in this issue?

Working at Rocky Flats	Page 2
TSR prepares records	Page 3
May Anniversaries	Page 3
Emergency exercise planned	Page 3
Fire Dept. achieves milestone	Page 3
Declassifieds	Page 4



# WORKING at Rocky Flats

**By Jackie Powers**

Driving along Central Avenue employees get one of the clearest pictures of the progress being made toward site closure. In March, B112 was demolished. April brought the elimination of B441 – the pink building with exterior peeling paint and dark windows. The west side of B334 also came down in April.

By the end of the fiscal year, the east side of B334 and B551 will be gone and the site will no longer rely on steam for its power. In early 2004, B865, B443, B115 and B116 are slated to be down. At that point, Central Avenue will have empty lots everywhere you look as the site begins to take the shape of a wildlife refuge.

For most, the visible signs of progress bring satisfaction and fulfillment. However, for some, the satisfaction is bittersweet. Many employees have spent their entire working life at Rocky Flats. The pride of contributing to our nation's security has slowly given way to the satisfaction of cleaning up the site for use by future generations.

The site is downsizing and if our friends and acquaintances are not gone, they will soon be moving on to new challenges. Below, employees share their thoughts about "Working at Rocky Flats." During interviews with employees around the site, it was clear that it's the people who have made Rocky Flats a special place to work, with many calling it a family.



**Joe Lucerna,**  
K-H Utilities Infrastructure Engineer – "After 27 years, I'd have to say I'll miss the diversity of the work the most, especially the production years. Taking down site utilities while ensuring those in neighboring buildings have what they need to continue their work is satisfying."



**Mike Davidson,**  
K-H Shift Superintendent – "I've worked at Rocky Flats for 31 years. At one time, the site was like a little city. Everything was possible. Imagine a high school graduate working hand in hand with chemists as a lab tech."



**David L. Martin, (left)**  
B460 D&D K-H Skilled Trade – "I will miss having lunch with my friends and the potlucks. I will also miss the wildlife - animals **and** people."

**Shelby James, (right)**  
K-H Material Stewardship D&D HRT – "I'll miss the friends I have made here. Hopefully we won't lose contact."

**Marie Castro,**  
SSOC Safeguards Coordinator and Holdup Accountability – "I will miss the camaraderie I have with my co-workers and everyone else here. Until recently, I had been in the same office for 17 1/2 years. I love my job. I will even miss my management! How many people can say that?"



**Bob Groke, (right)**  
K-H, Senior HR Specialist, – "I've enjoyed working with so many different people over my 24 years at Rocky Flats. This place is not routine, but I've always found it to be an enjoyable challenge."



**Ed George,**  
RFCSS Warehouse Supervisor – "I've worked at Rocky Flats for 10 years and I'll have to say that I'll miss the people the most. We're a family. I will also miss the detective work involved in tracking down lost material."



**Nancy Lymborn, (left)**  
CH2M Hill, Help Desk Manager – "In my three years at Rocky Flats, I've found that the only constant out here is inconsistency."

**Greg Slay, (right)**  
K-H Material Stewardship D&D HRT  
"I love the paychecks."



**Tim McGrath, (left)**  
Source One, Senior Photographer – "The closure project is something very worthwhile. I am excited to be a part of making our community a better place to live."  
**Sheri Margit, (right)**  
Source One, Mail Courier – "The best part about this job is all the treats all the building people share with me."



**Greg Moore, (left)**  
DOE, General Engineer – "I've been here for 13 1/2 years and have seen the challenge change from keeping the site open to it's accelerated closure."



**Kim Timmons,**  
(above right, next to Bill Schoser) B460 D&D HRT – "I'll miss Hairy Bear (Schoser) and the benefits and money."



**Edette Nichols,**  
Critique, DOE Managers Office Support – "I know only a handful of people will be here the final day of closure, but it would be really neat to witness it."







Above, Craig Nesshoefer, TSR supervisor, scans training records into the database so the paper originals can be transferred to the Federal Center for 75-year storage. The records for a single employee, such as those stacked to his right, can consist of hundreds of pages. Marian Patt, left, removes the staples from a stack of training records so the pages can be scanned, one of the time consuming tasks associated with storing training record information electronically.

# TSR prepares records for final storage

By Bob Darr

One constant that everyone working at Rocky Flats shares is the ever-growing amount of paper-work that tracks an individual's training history.

Every site worker is required to undergo some level of training, from the GERT course that is required to simply get on site, to radiological and hazardous material training for those who actually work around dangerous substances.

When you consider that the site is required to maintain training

records for every person who has performed work at Rocky Flats since the early 1950s, you begin to appreciate how large a task it is to maintain these records.

Approximately 200 secure file cabinets, or safes, hold the original training records for thousands of site employees. With closure of the site nearing, the Training Scheduling and Records Department (TSR) must prepare all records for off-site storage.

"We're basically moving 1.5 million pieces of paper, from site record storage safes to the Federal Center in Lakewood, where they

will go into storage for 75 years," said Craig Nesshoefer, TSR supervisor. "We estimate it will take about 700 boxes to move it all."

Before the files can be boxed up and moved, they are scanned into a computer database so they can be accessed on site. First, each set of records is assigned a bar code number. Then the system reads the bar code, verifies that it is the right record and scans the individual documents into an electronic folder.

"If someone needs a copy of a particular training record, we enter the name and quickly pull up and

print out what's needed," Nesshoefer said. "Original copies can be retrieved from the Federal Center if they're needed."

Nesshoefer and his team, Marian Patti, Karen Bristol and Lisa Hillesand, started scanning and packing files last December and expect to have all the files in the computer system by September. Paper copies of new training records for active employees will be kept on site for one-to-two years, then will be scanned and sent to storage as the site closes, he said.

## Emergency response exercise planned

The site will be conducting an emergency response exercise Wednesday morning, June 4, 2003. This exercise will test a variety of site emergency response capabilities including demonstration of on-site sheltering.

All employees are to follow the instructions provided over the LS/DW system. In the event of a real emergency, the exercise may be terminated.

Questions regarding the upcoming exercise should be directed to the exercise director, Dick Burns, x8080.

Requests for exercise exemptions should be directed to Bob Kopplin, x6331.

YOUR PARTICIPATION AND  
COOPERATION IS VITAL TO THE  
SUCCESS OF THE EXERCISE!

## Fire Department reaches five-year mark without lost-workday injury

Congratulations to the Rocky Flats Fire Department for their long-term commitment to safety.

On May 8, 2003, the Fire Department achieved a significant safety milestone – five years without a lost-workday injury. Thanks to the Fire Department for their vigilance and dedication to safety while supporting the site closure mission.

# May Anniversaries

<b>Five Years</b> Darris D. Griffin, K-H Melinda J. Rael, K-H	<b>Fifteen Years</b> Robert J. Gerry, WSLC Darrell E. Johnson, K-H Mathew J. Schatz, RFCSS	Lloyd H. MacDonald, K-H Michael C. Mills, RFCSS Kerry L. Minter, K-H Charles B. Munger, K-H Patrick F. Nelson, K-H Richard A. Nelson, K-H Dennis A. Shepherd, K-H Thomas J. Steinbrunn, K-H Andrew L. Tafoya, K-H Michael Thompson, WSL Edmund L. Vallee, Jr., WSL Kevin M. Wiebe, RFCSS
<b>Ten Years</b> John E. Allen, K-H Michael L. Bemski, RFCSS Stephanie L. Davis, K-H Harold W. Dutton, K-H Lynne M. Gray, RFCSS Shawn L. Haynes, K-H Alfred Neal Mullins, RFCSS Robert D. Plappert, K-H	<b>Twenty Years</b> Michael J. Costanten, K-H John A. Flinchum, K-H David J. Fowler, K-H John A. Geis, K-H Barry A. Gilbert, RFCSS Shirley J. Heisz, K-H Richard L. Hill, RFCSS Charles E. Holloman, K-H Donald B. Johnston, K-H	<b>Thirty-five Years</b> John K. Fraser, RFCSS

## envision

is published every other Wednesday for the benefit of all Rocky Flats employees. We invite your letters to the editor, story suggestions and comments. The deadline for approved stories is 10 a.m. on the Monday following AWS-Friday.

Vol. 9, No. 10, May 21, 2003

**Editor:** Jackie Powers, 303-966-5416  
Mail stop T117A, Cube 59  
jackie.powers@rfets.gov

**Contributing to this issue:**

Bill Badger  
Jeanna Blatt  
Bob Darr  
Lara Harrison  
Joel Zarrett

**Rocky Flats Photography Department  
Rocky Flats Trucking Department**



# Steelworkers continued from Page 1

Kaiser-Hill was able to offer qualified and multi-skilled workers to the client under an agreement with the Steelworkers Union. Sheet metal workers, pipefitters, electricians and plumbers with Q-clearances were required for the project that involved building a one-million-gallon fuel system with all the pumps, piping, electrical work and welding that goes with it. This required setting and welding more than 125 tons of steel, sandblasting it and, finally, applying three coats of a high grade epoxy paint.

The client also required that the tanks be built with an interior, floating roof to reduce the potential for fire and evaporation. Even in the dead of winter, sides of the jet fuel tanks could potentially reach 150 degrees. The Rocky Flats Steelworkers team completed the job with no first aids, no recordable injuries and no lost workdays. The 15 employees worked long shifts, 10-hour days for up to 16 days in a row before flying home to Denver for a short rest

after each cycle.

After more than nine months on the project, the team returned to Rocky Flats in mid-April. The complex and all of the safety systems, both electrical and mechanical were recently tested over a two-week period and performed flawlessly.

Kaiser-Hill President and CEO Alan Parker congratulated the team at a recognition luncheon held on April 30, saying, “We are so proud of the work you did. It is pretty easy to sell success, and your safety record will keep these opportunities coming.” Kaiser-Hill Vice President and CFO Len



Kaiser-Hill Vice President and CFO Len Martinez presented each member of the team with a few items of appreciation at a recognition luncheon. Seated from left are Al Amador and Howard Hall.

Martinez also relayed a message from the project’s base commander expressing his appreciation for the dedication and commitment of the team.

# declassifieds

## ANIMALS

Horse boarding: Brighton-Henderson area, box stall, 110-ft. run, arena privileges, feed twice a day. Barbara, 303-659-7539.

## AUTOMOBILES/MOTORCYCLES

1969 Ford Ranchero, runs and passed emissions, \$1,000 or best offer; 1997 Chevrolet extended cab, \$14,000. Dawn, 303-456-1327.

1971 MGB, by original owner, body completely redone, new top, excellent runner, \$6,830 or best offer. Roger, 303-430-0312.

1978 Chevy pickup, 90 percent restored with custom paint job, ¾ ton, 4x4, 1-ton suspension, low miles on rebuilt engine, new tires, \$7,000 negotiable, one clean truck! Martha, 303-452-2978, after 6 p.m.

1985 Jeep Cherokee, 2-door, 4-wheel drive, 130,000 miles, looks good, runs good, \$1,300 or best offer. Chuck, 303-642-7449.

1993 Suburu Loyale, one owner, well-maintained, runs fine, \$1,200. Nancy, 303-582-3536.

1994 Cadillac Eldorado, 2-door, gold w/tan leather interior 54,000 miles, excellent condition, \$9,000. Bob, 303-422-2216.

1994 Sportster XLH883, black, one owner, ready to ride, windshield, King tank, tach, bags, Corbin, chrome, can e-mail pictures, \$4,900. Steve, 303-989-8140.

1997 Ford Explorer, Eddie Bauer, V8, AWD, 68,000 miles, leather, loaded, \$8,000. Art, 303-420-8338.

1998 Mustang, 5-speed, 57,000 miles, red/black interior, alloy wheels, power interior, cruise control, premium CD and tape, \$8,000. Jack, 303-423-2120.

1999 Mercury Villager, well equipped, new tires, 44,000 miles, \$14,000. Dionisio, 303-961-1548.

## MISCELLANEOUS

Wooden bunk bed with two mattresses and two box springs, will convert into separate beds. Good condition. \$250. Judy, 720-872-1788.

Men’s mountain/city bicycle, lightweight manganese-steel frame, 26-inch aluminum rims, 18-speed Shimmano shifter, center-pull brakes, classic metallic gray, new tire, ready to cruise the greenbelt, \$55; girl’s beginner bicycle, 12-in. white tires, training wheels, pink frame, \$9. Leigh, 303-403-1066.

Whirlpool electric clothes dryer, new element, runs well, \$35. Jim, 720-304-2152.

Kenmore washer and natural gas dryer, must sell both for \$50. Brett, 720-890-6069.

Sliding glass door, approximately 78-in. high by 72-in. wide, two years old, excellent condition, \$175. Harry, 720-685-7171.

Baby Grand piano, \$1,000. Ken, 303-679-3585.

Solid alder wood entertainment center, holds up to 36-in. TV, 5.5-ft. long by 5-ft. high by 1.5-ft. depth, storage cabinets below and component rack along the left side, \$600. Adam, 303-421-8284.

Six-piece antique, French provincial bedroom set, dark stained mahogany or cherry, full-size bed, two night stands, two large dressers, large mirror, \$2,500. Greta, 303-581-9694.

Four-section, spike-tooth harrow, \$450; 12-ft. mulcher, \$1,000; 10-ft. grain drill, \$1,000; 3-pt. post-hole digger, 2 augers, \$250. Ken, 303-637-0531.

Need a weekend getaway? Rent this Frisco condo: two blocks off main street, 3 bedrooms that sleep 6, two baths, kitchen, barbecue grill, indoor pool and hot tub, \$105/night plus tax, three-night minimum, great for family reunions, free use of club house, call for availability. Donna, 303-420-6848.

Broncos tickets: two 45-yard-line tickets, east side, Section 533, Row 11, face value of \$970. Gary, 303-665-5531.

Baldwin piano, walnut, upright, like new, \$500 or best offer. Debby, 303-432-1203.

## TRAILERS/CAMPERS/BOATS

1980 Lowe Line 14-ft. aluminum boat and trailer, 6 hp Evenrude outboard motor, many extras, excellent condition, \$1,700 firm. Jerry, 303-278-0664.

1991 Arriva, 19-ft. open bow 150 Black Max OB, low hours, garaged, mint condition, red and white. Brent, 720-479-5988.

1995 single place personal watercraft trailer, excellent condition, \$250 or best offer. Dan, 303-466-6432.

## WANTED

Color monitor for a Macintosh computer. Brett, 720-890-6069.

1983 or newer 258 inline 6 engine, in good condition, ready to put in vehicle, reasonable price. Dan, 303-430-4289.

Roommate to share house, 12 minutes from East Gate. Mark, 720-272-2009.

## Declassifieds

- Only Rocky Flats Site employees are eligible to place ads.
- Please use the form at right to submit your ad. Or send your ad via e-mail to Jackie Powers, or via the Intranet (Home Page/News & Info/Communication Division/Declassifieds).
- Ads should be no more than 20 words.
- Check category in which the ad is to be included.
- Home phone numbers must be used in the ads, except for items in the Lost/Found and Vanpools/Carpools categories.
- Site extension must be included (in case information needs to be verified).
- Only one ad per issue (ads will not be re-run unless they are resubmitted).
- Ads for garage sales or personal businesses will not be run.
- Ads for real estate can be placed only by owners and will include the phrase “for sale by owner.”
- No ads for guns/other weapons will be accepted.
- Mail or bring ads to T117A, Cube 59.
- Declassifieds are accepted on a first-come basis.
- Deadline is six working days before the desired publication date.
- Employees who submit fictitious ads will be subject to disciplinary action based on company standards of conduct.

### Category (check one)

- Animals
- Automobiles/Motorcycles
- Lost/Found
- Miscellaneous
- Trailers/Campers/Boats
- Vanpools/Carpools
- Wanted

Text:

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

Name (first and last): \_\_\_\_\_

Home phone: \_\_\_\_\_ Site extension: \_\_\_\_\_